

Work Order ID 115148

April-24-14 9:24:43 AM

repair
~~115148~~
115148

Page 1

Item ID: D3529-1

Revision ID:

Item Name: Bearpaw

Start Date: 3/17/14

Start Qty: 10.00

10

Required Date: 3/17/14

Req'd Qty: 10.00

10

Reference:

Approvals:

Process Plan: *W*

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3529	Rev A								

110

110

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

CUT BLANK AS PER FILE D3529-1BLANK

0.00

0.00

10 0 Jm14-04-26

120

120

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Inspect material for defects or damage prior to machining2-Machine as per Folio FA645 and Dwg D35293-Debur

0.00

0.00

DAS

02

9-00

10 14 04-26 JFC 2014-04-29

130

130

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

DAS

02

9-00

10 14-04-26

Work Order ID 115148

April-24-14 9:24:43 AM

115148

Page 2

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Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run

Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC8- Inspect parts - second check

0.00

140

QC

Memo

0.00

Quality Control

10 ϕ 14.04.30

150

Identify as per dwg & Stock Location: _____

0.00

150

Packaging

Memo

0.00

Packaging

14/4/30 @ DAS
32
9-89

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ 14-05-01

14.4.30

Picklist Print

April-24-14 9:24:43 AM

Page 1

Work Order ID: 115148

115148

Parent Item: D3529-1

D3529-1

Parent Item Name: Bearpaw

Start Date: 3/17/14

Required Date: 3/17/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 06-06-28 JLM
IPP Rev:B New Manufacturing Method 08-11-27 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased		No		100	sf	817.7082	1.265	14			

MIJHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

Jm14-04-26

Location

Loc Qty

Loc Code

MAT018

817.7082

121278

9.6282

122575

47.6

123229

53

123949

6.96

124758

17.52

m128011

57

m128267

226

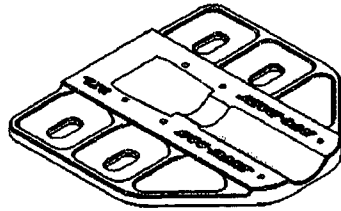
m128668

400

128067

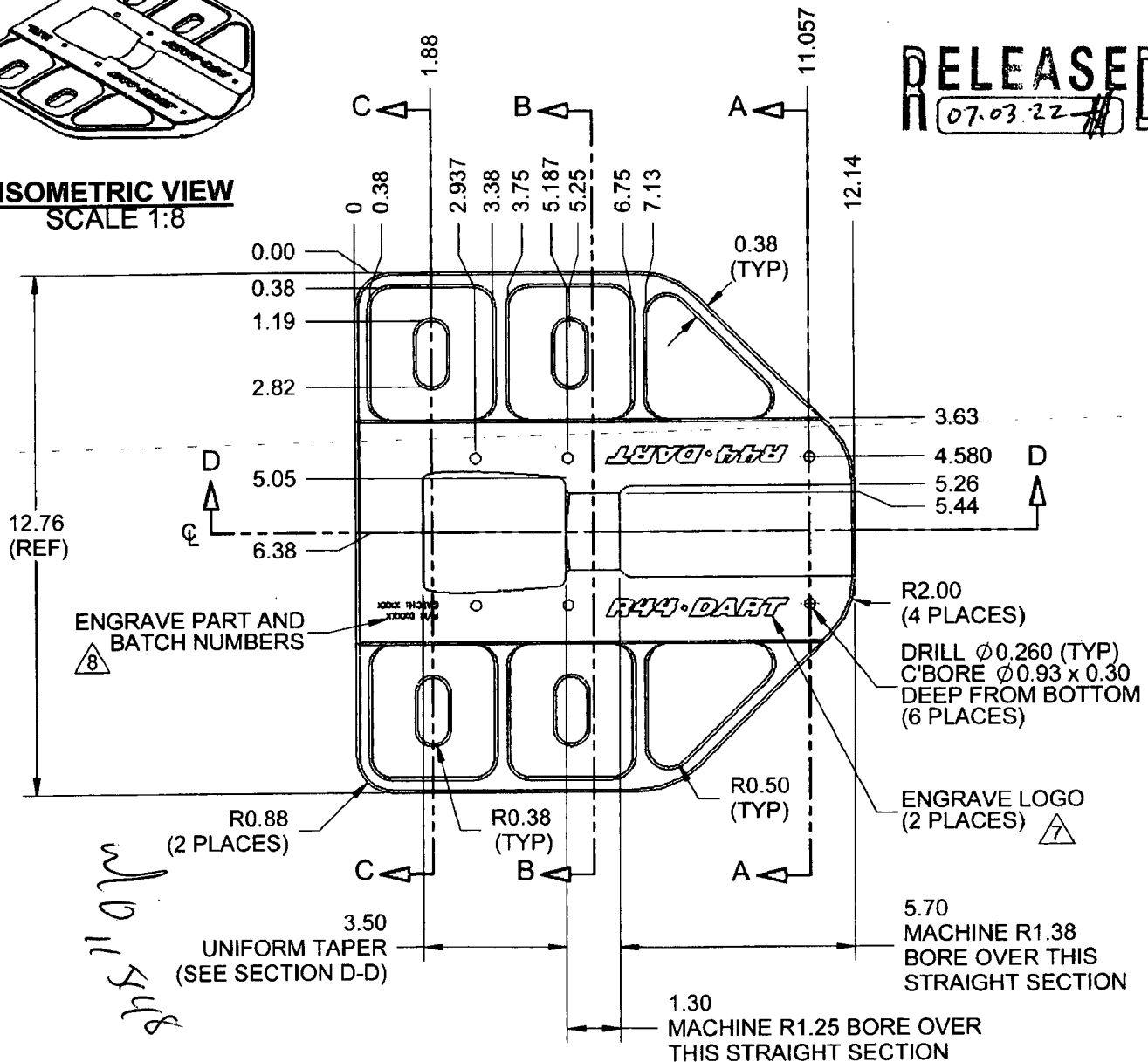


DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3529	REV. A SHEET 1 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4
REV A	DATE 07.01.04	DESCRIPTION NEW ISSUE	



ISOMETRIC VIEW
SCALE 1:8

RELEASED
07.03.22



D3529-1 R44 BEARPAW

NOTES:

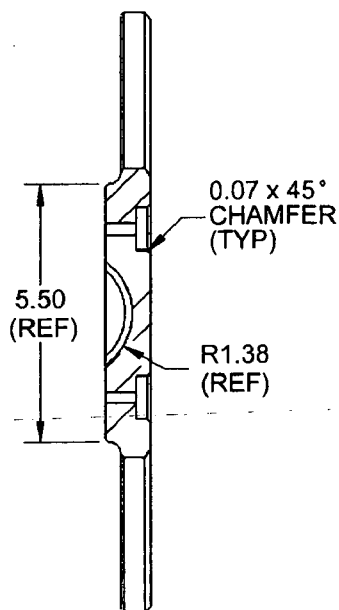
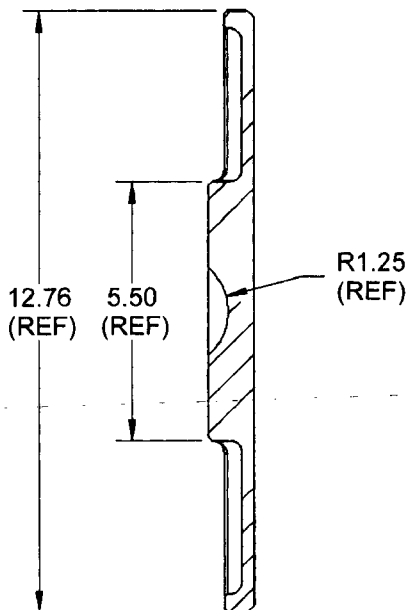
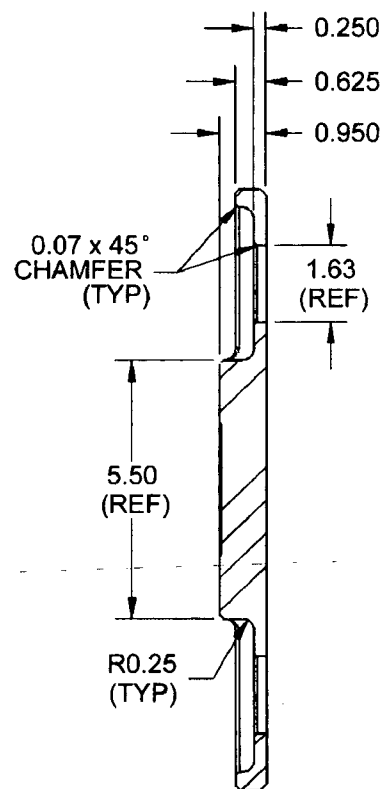
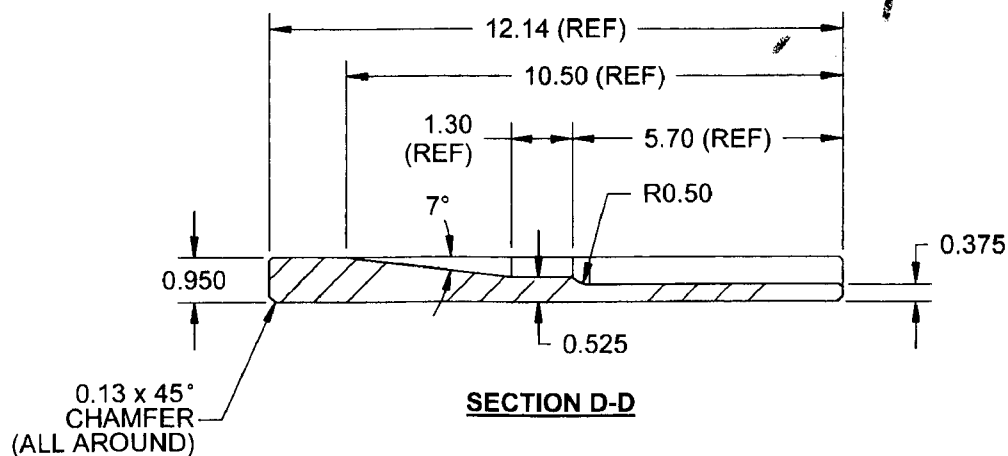
- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3529	REV. A SHEET 2 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4

RELEASED
07.03.22**SECTION A-A****SECTION B-B****SECTION C-C****SECTION D-D****COPYRIGHT © 2007 BY DART AEROSPACE LTD**

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DART AEROSPACE LTD		Work Order: 115048
Description: Bearpaw		Part Number: D3529-1
Inspection Dwg: D3529 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	5.50	+/-0.030	5.500	✓		gene	RT-4
B	0.07 x 45°	+/-0.030 x 0.5°	0.045	✓			
C	R0.25	+/-0.030	R0.250	✓			
D	0.250	+/-0.010	0.252	✓		mid	RT-1
E	0.625	+/-0.010	0.630	✓			
F	0.950	+/-0.010	0.958	✓			
G	1.63	+/-0.030	1.619	✓			
H	12.14	+/-0.030	12.14	✓		Type	RT-10
I							
J	5.70	+/-0.030	5.720	✓			
K	0.375	+/-0.010	0.383	✓			
L	0.525	+/-0.010	0.535	✓			
M	0.13 x 45°	+/-0.030 x 0.5°	0.125	✓			
N	R0.50	+/-0.030	0.50	✓			
O	12.76	+/-0.030	12.76	✓			
P	3.38	+/-0.030	3.38	✓			
Q	3.75	+/-0.030	3.75	✓			
R	5.187	+/-0.010	5.187	✓			
S	5.25	+/-0.030	5.250	✓			
T	7.13	+/-0.030	7.130	✓			
U	Ø0.260	+0.006/-0.001	0.260	✓			
V	0.30	+/-0.030	0.290	✓			
W	0.93	+/-0.030	0.930	✓			
X	1.30	+/-0.030	1.276	✓			

Measured by: DAS	Audited by: DR	Prototype Approval:	N/A
Date: 14 May 2008	Date: 14.04.30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	
B	08.05.06	Dimension I removed	KJ/DD	